



FIG. 1

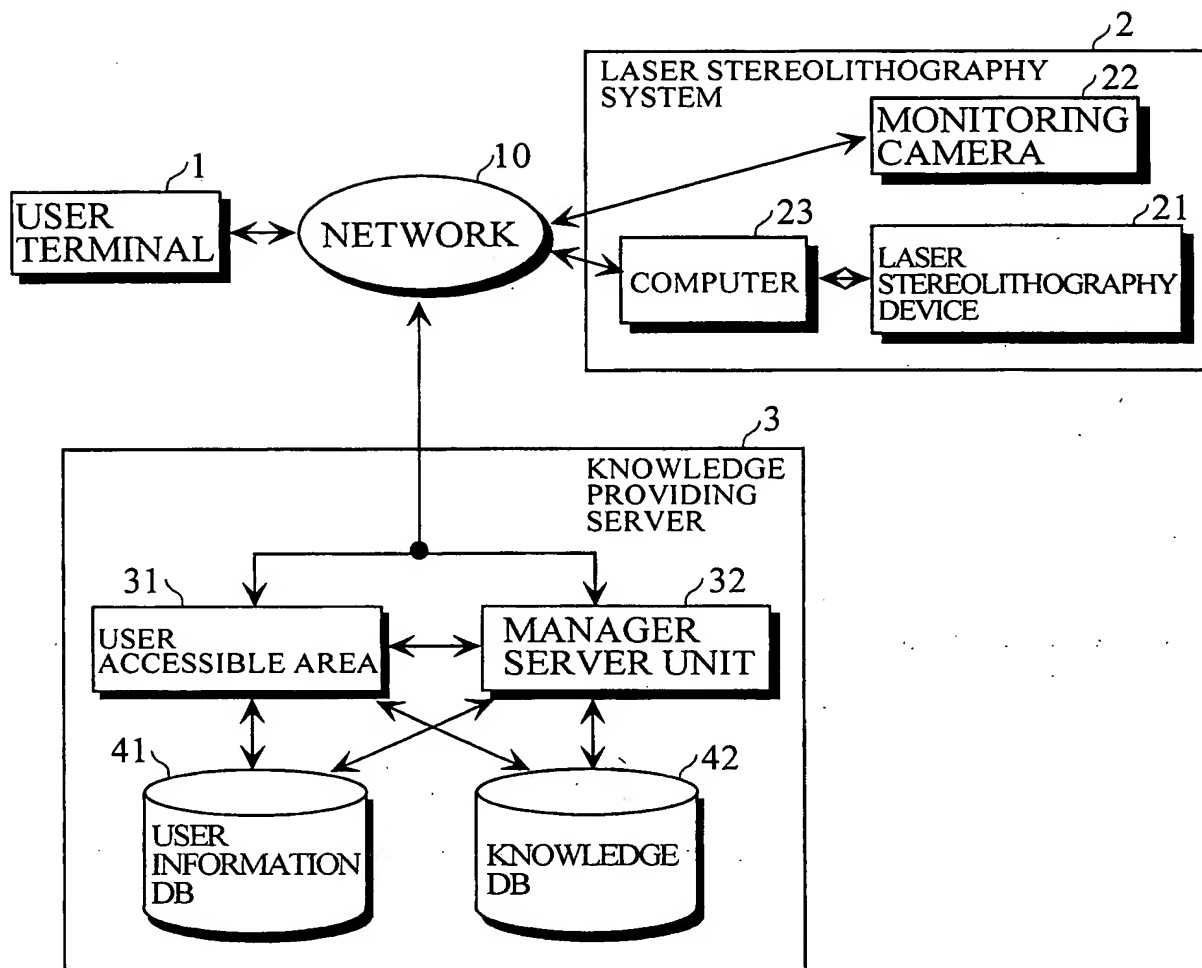


FIG. 3

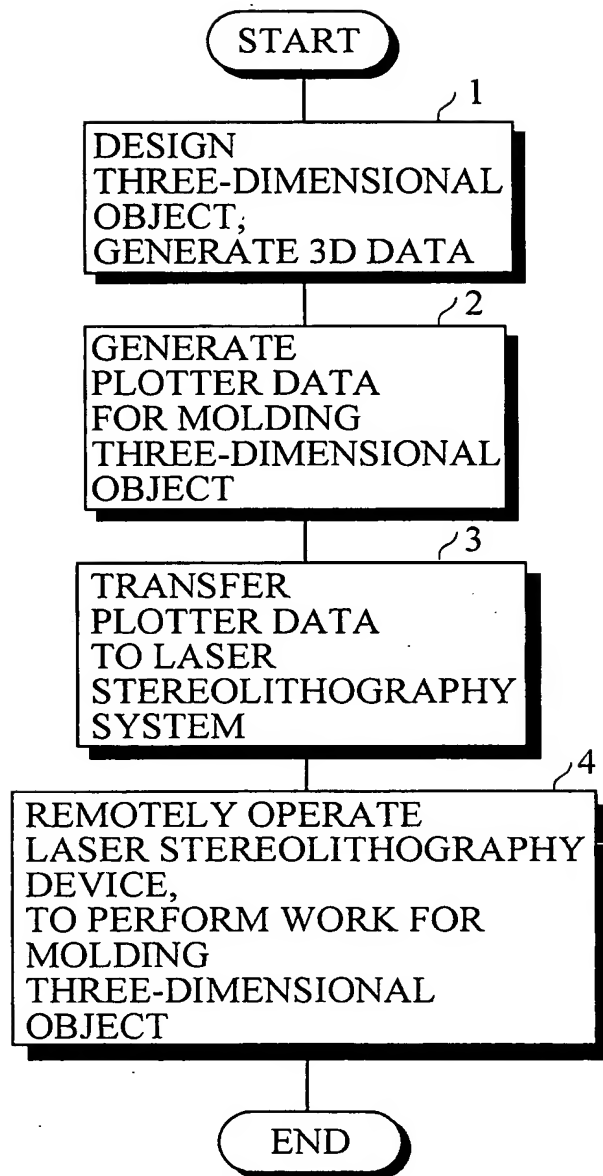


FIG. 4

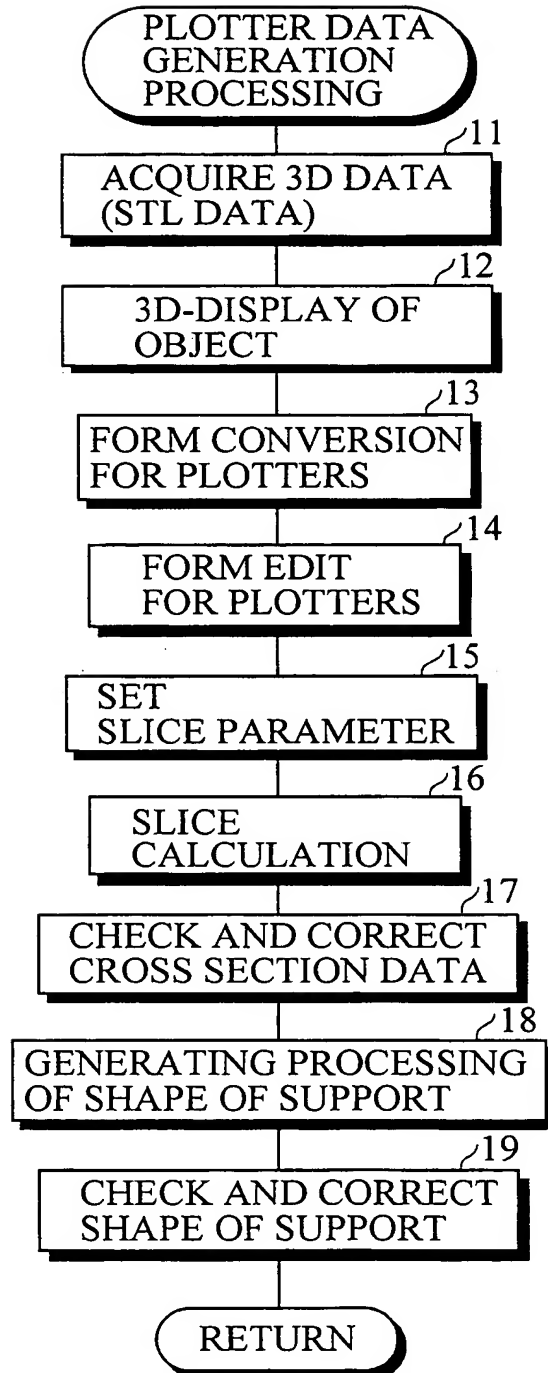


FIG.5

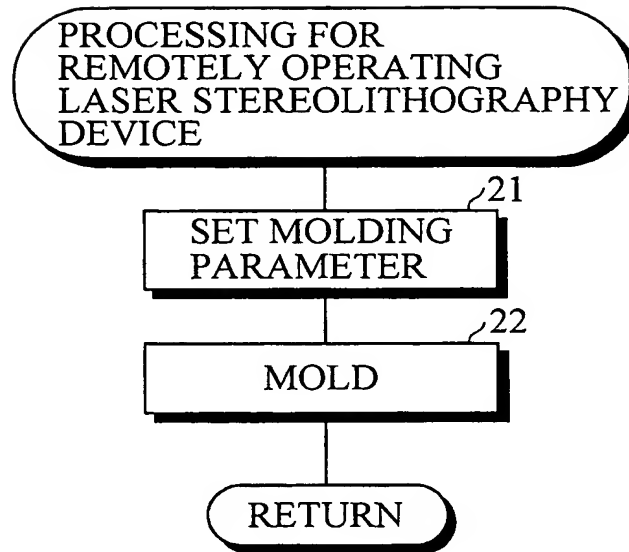


FIG.6

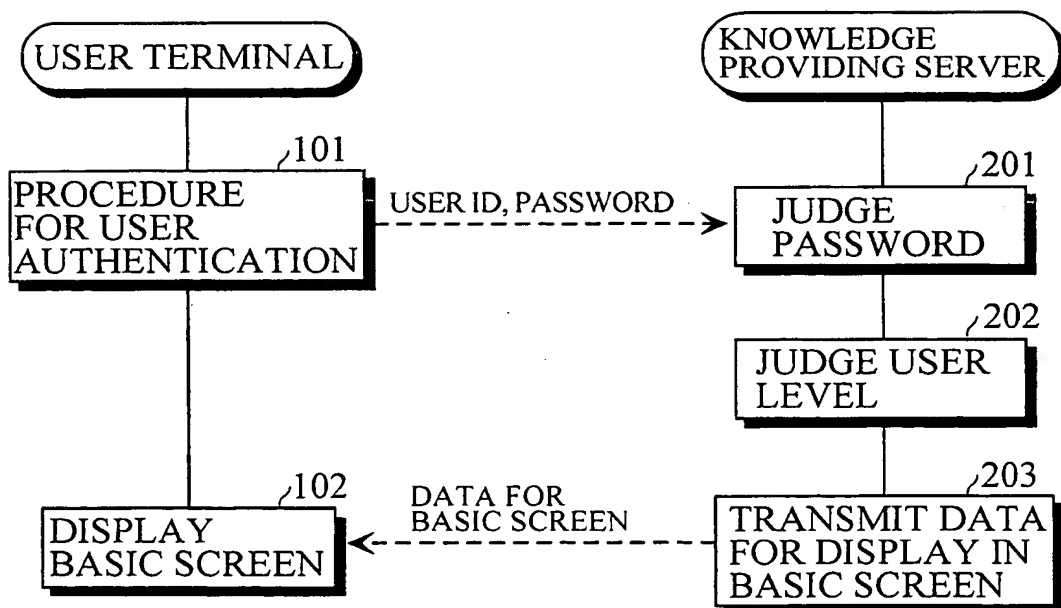


FIG.7

The image shows a web browser window with a menu bar containing 'FILE(F)', 'EDIT(E)', 'DISPLAY(V)', 'FAVORITE(A)', 'TOOL(T)', and 'HELP(H)'. Below the menu bar is a 'RETURN' button. The address bar shows 'ADDRESS' followed by a globe icon and the URL 'http://xxxxxx/xxx.xxx'. The main content area contains a login form with the following elements:

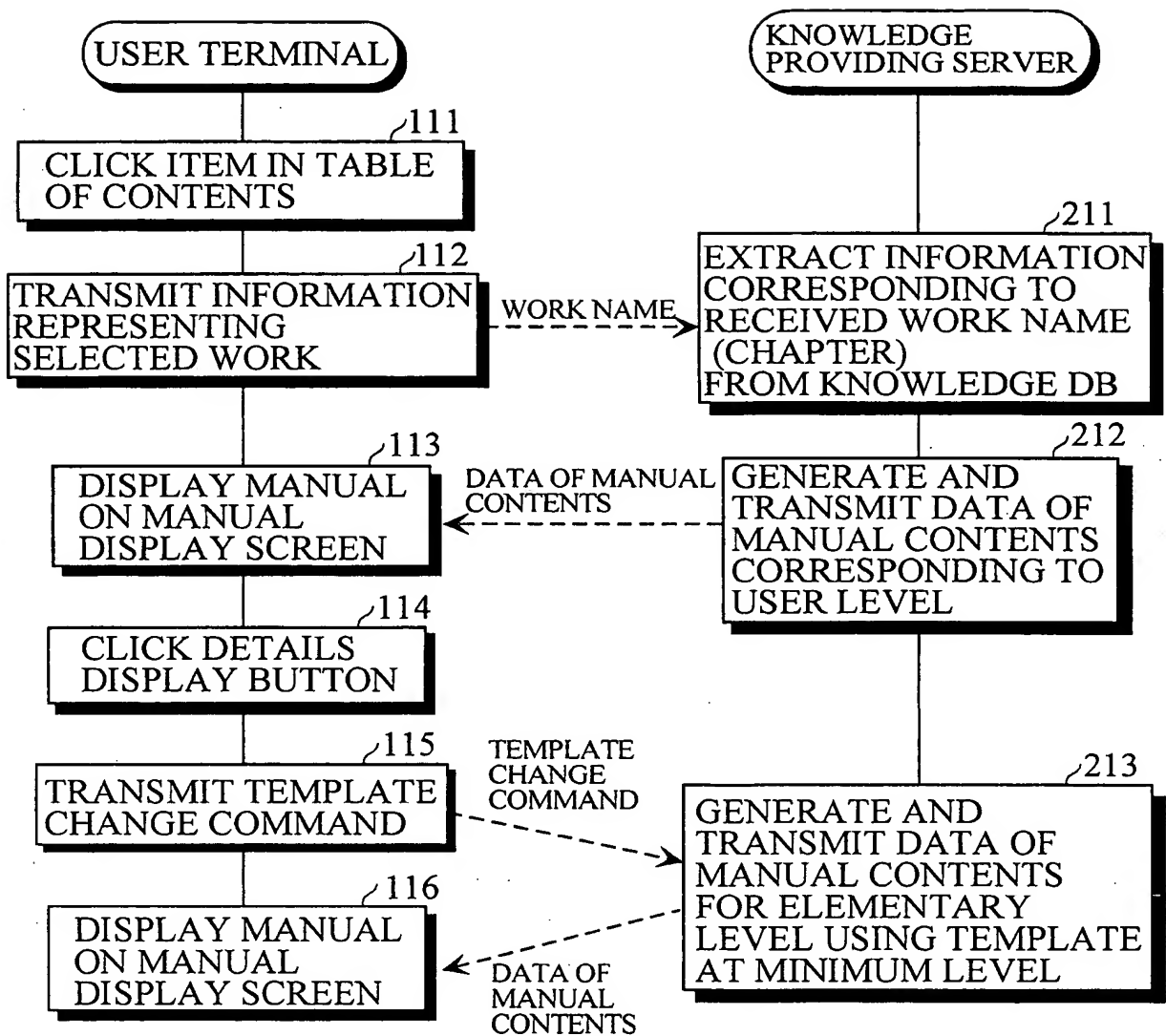
- 'USER ID' label followed by a text input field.
- 'PASSWORD' label followed by a text input field.
- An 'OK' button centered below the input fields.

The browser window includes standard window controls (minimize, maximize, close) in the top right corner and a status bar at the bottom.

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
RETURN	
ADDRESS <input type="text" value="http://xxxxxx/xxx.xxx"/>	
<div style="border: 1px solid black; padding: 5px;"> <div style="display: flex; justify-content: space-between;"> <div> USER NAME USER 1 LEVEL OF SKILL 1 </div> <div> KNOW-HOW RETRIEVAL 61 FAILURE CASE RETRIEVAL 62 </div> </div> <div style="margin-top: 10px;"> <input type="text"/> RETRIEVAL 63 </div> </div>	<div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center;">TABLE OF CONTENTS</p> <p>CHAPTER 0 BEFORE WORK</p> <p>CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER</p> <p>CHAPTER 2 EDITING OF SHAPE FOR PLOTTER</p> <p>CHAPTER 3 SLICING</p> <p>CHAPTER 4 CROSS SECTION EDITING</p> <p>CHAPTER 5 AUTOMATIC MAKING SUPPORT</p> <p>CHAPTER 6 MANUAL MAKING SUPPORT</p> <p>CHAPTER 7 DATA TRANSFER</p> <p>CHAPTER 8 REMOVAL OPERATION</p> <p>CHAPTER 9 SETTING OF LIQUID SUREACE OF RESIN</p> <p>CHAPTER 10 MOLDING ARRANGEMENT</p> <p>CHAPTER 11 COATING PARAMETER SETTING</p> <p>CHAPTER 12 EXPOSURE PARAMETER SETTING</p> <p>CHAPTER 13 MOLDING</p> <p>CHAPTER 14 REMOVAL</p> <p>CHAPTER 15 WASHING AND SUPPORT REMOVAL</p> <p>CHAPTER 16 SECONDARY CURING</p> </div>

TABLE OF CONTENTS	
CHAPTER 0	BEFORE WORK
CHAPTER 1	CONVERSION OF SHAPE FOR PLOTTER
CHAPTER 2	EDITING OF SHAPE FOR PLOTTER
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CHAPTER 4	CROSS SECTION EDITING
CHAPTER 5	AUTOMATIC MAKING SUPPORT
CHAPTER 6	MANUAL MAKING SUPPORT
CHAPTER 7	DATA TRANSFER
CHAPTER 8	REMOPT OPERATION
CHAPTER 9	SETTING OF LIQUID SURFACE OF RESIN
CHAPTER 10	MOLDING ARRANGEMENT
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CHAPTER 12	EXPOSURE PARAMETER SETTING
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CHAPTER 14	REMOVAL
CHAPTER 15	WASHING AND SUPPORT REMOVAL
CHAPTER 16	SECONDARY CURING

FIG.9



FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
↩ RETURN	<input type="button" value="X"/> <input type="button" value="□"/> <input type="button" value="■"/>
ADDRESS [http://xxxxxx/xxx.xxx]	
<p>USER NAME USER 1 LEVEL OF SKILL 1</p> <p><input checked="" type="radio"/> KNOW-HOW RETRIEVAL 61 <input type="radio"/> FAILURE CASE RETRIEVAL 62 <input type="radio"/> RETRIEVAL 63</p> <p>TABLE OF CONTENTS</p> <ul style="list-style-type: none"> CHAPTER 0 BEFORE WORK CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER CHAPTER 2 EDITING OF SHAPE FOR PLOTTER CHAPTER 3 SLICING CHAPTER 4 CROSS SECTION EDITING CHAPTER 5 AUTOMATIC MAKING SUPPORT CHAPTER 6 MANUAL MAKING SUPPORT CHAPTER 7 DATA TRANSFER CHAPTER 8 REMOINT OPERATION CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN CHAPTER 10 MOLDING ARRANGEMENT CHAPTER 11 COATING PARAMETER SETTING CHAPTER 12 EXPOSURE PARAMETER SETTING CHAPTER 13 MOLDING CHAPTER 14 REMOVAL CHAPTER 15 WASHING AND SUPPORT REMOVAL CHAPTER 16 SECONDARY CURING 	<p>CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER</p> <hr style="border-top: 1px dashed black;"/> <p>1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER</p> <p>Select "① editing of a shape for a plotter" from an application menu in protter data editor.</p> <p>KNOW-HOW It is also possible to start plotter data editor from a start menu.</p> <div style="border: 1px solid black; height: 100px; margin: 10px auto; width: 150px; text-align: center; line-height: 100px;">IMAGE</div> <p>1_02 STL DATA READING</p> <p>Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter.</p> <p>KNOW-HOW It is possible to convert a plurality of data at a time.</p> <div style="display: flex; justify-content: space-around; margin: 10px auto;"> <div style="border: 1px solid black; height: 100px; width: 150px; text-align: center; line-height: 100px;">IMAGE</div> <div style="border: 1px solid black; height: 100px; width: 150px; text-align: center; line-height: 100px;">IMAGE</div> </div> <p>1_03 PROCESSING CONDITION SETTING</p> <p>Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit.</p> <p>KNOW-HOW Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit.</p> <div style="display: flex; justify-content: space-around; margin: 10px auto;"> <div style="border: 1px solid black; height: 100px; width: 150px; text-align: center; line-height: 100px;">IMAGE</div> <div style="border: 1px solid black; height: 100px; width: 150px; text-align: center; line-height: 100px;">IMAGE</div> </div>

<div style="display: flex; justify-content: space-between;"> FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div>	
RETURN	ADDRESS http://xxxxx/xxx.xxx

USER NAME USER 3 LEVEL OF SKILL 3	61 KNOW-HOW RETRIEVAL 62 FAILURE CASE RETRIEVAL	RETRIEVAL	65
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TABLE OF CONTENTS	<div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>CHAPTER 0 BEFORE WORK</p> <p>CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER</p> <p>CHAPTER 2 EDITING OF SHAPE FOR PLOTTER</p> <p>CHAPTER 3 SLICING</p> <p>CHAPTER 4 CROSS SECTION EDITING</p> <p>CHAPTER 5 AUTOMATIC MAKING SUPPORT</p> <p>CHAPTER 6 MANUAL MAKING SUPPORT</p> <p>CHAPTER 7 DATA TRANSFER</p> <p>CHAPTER 8 REMOTE OPERATION</p> <p>CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN</p> <p>CHAPTER 10 MOLDING ARRANGEMENT</p> <p>CHAPTER 11 COATING PARAMETER SETTING</p> <p>CHAPTER 12 EXPOSURE PARAMETER SETTING</p> <p>CHAPTER 13 MOLDING</p> <p>CHAPTER 14 REMOVAL</p> <p>CHAPTER 15 WASHING AND SUPPORT REMOVAL</p> <p>CHAPTER 16 SECONDARY CURING</p> </div> <div style="width: 48%;"> <p>CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER</p> <hr/> <p>1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER</p> <p>Select "① editing of a shape for a plotter" from an application menu in protter data editor.</p> <p>1_02 STL DATA READING</p> <p>Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter.</p> <p>1_03 PROCESSING CONDITION SETTING</p> <p>Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit.</p> <p>1_04 START OF PROCESSING</p> <p>Execute conversion processing.</p> <p>1_05 TERMINATION OF APPLICATION</p> <p>Select "the end of an application" from a menu, to perform termination processing.</p> </div> </div>
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FIG.12

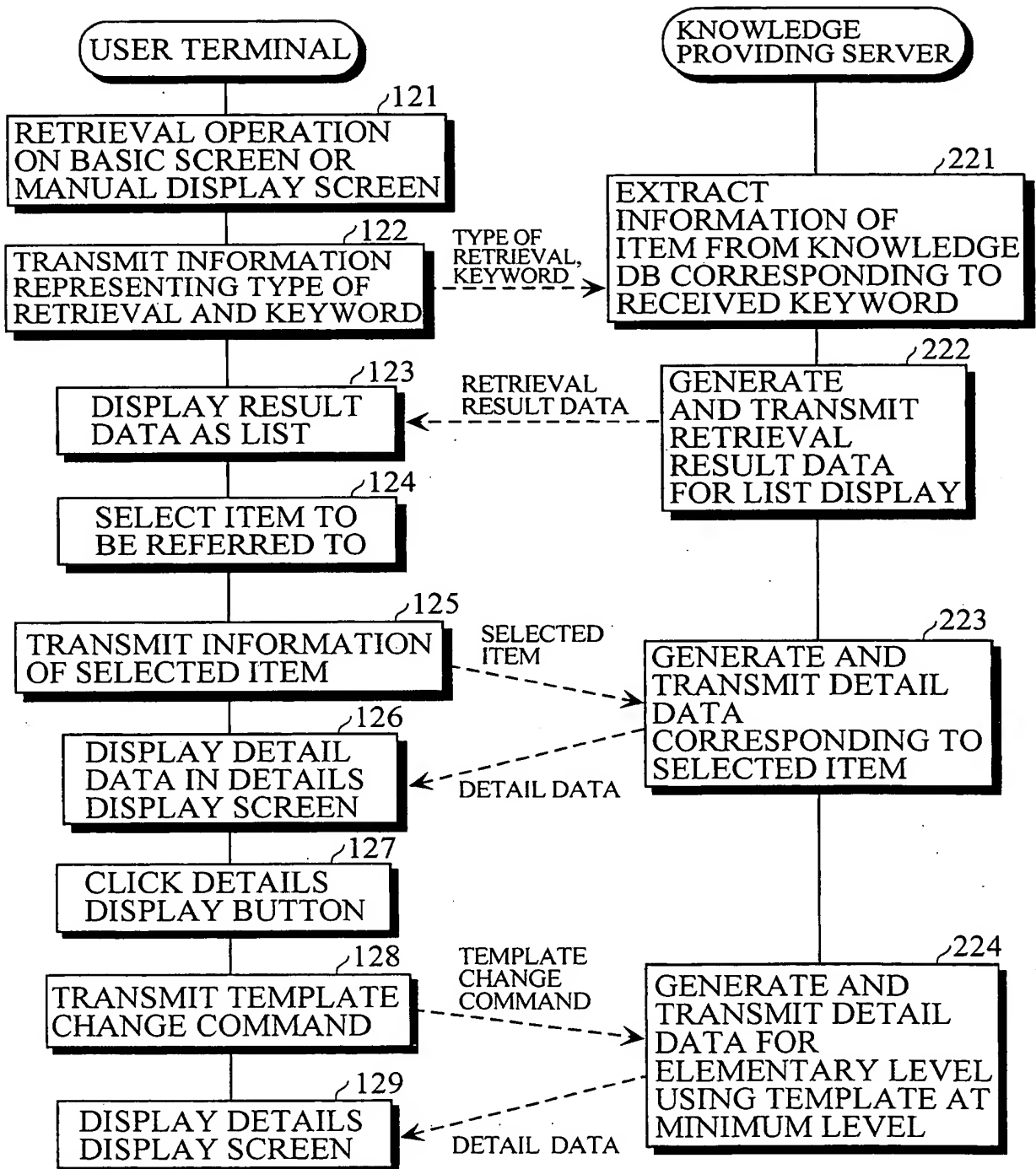


FIG.13

The image shows a web browser window with a menu bar (FILE(F), EDIT(E), DISPLAY(V), FAVORITE(A), TOOL(T), HELP(H)), a 'RETURN' button, and an address bar containing 'http://xxxxx/xxx.xxx'. The main content area displays a table titled 'LIST OF RESULTS'.

NUMBER OF CLAUSE	WORK NAME	PRECONDITIONS + KNOW-HOW
1_03	Processing Condition Setting	<u>Generally, millimeter is a unit.</u> <u>Confirm because there is a case where inch or the like is a unit.</u>

The table is rendered with dashed borders. The browser window includes standard window controls (minimize, maximize, close) in the top right corner and a status bar at the bottom.

FIG. 14

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
↩ RETURN	
ADDRESS http://xxxxxx/xxx.xxx	

DETAILS DISPLAY

DETAILS DISPLAY

KNOW-HOW	<p>Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit.</p>	
RELATED IMAGE	IMAGE	
CASE WHERE THIS KNOW-HOW IS NOT USED	Molded in different size	

FIG.15

FAILURE	CAUSE
A molding time period is lengthened.	Because it takes long to perform exposure and coating per layer.
A knife is brought into contact with a model for a long time so that the model is liable to be destroyed when a molding time period is increased and the knife moves.	Because the distance a knife moves is increased, and the probability that the knife is caught by the model is increased.

FIG.16

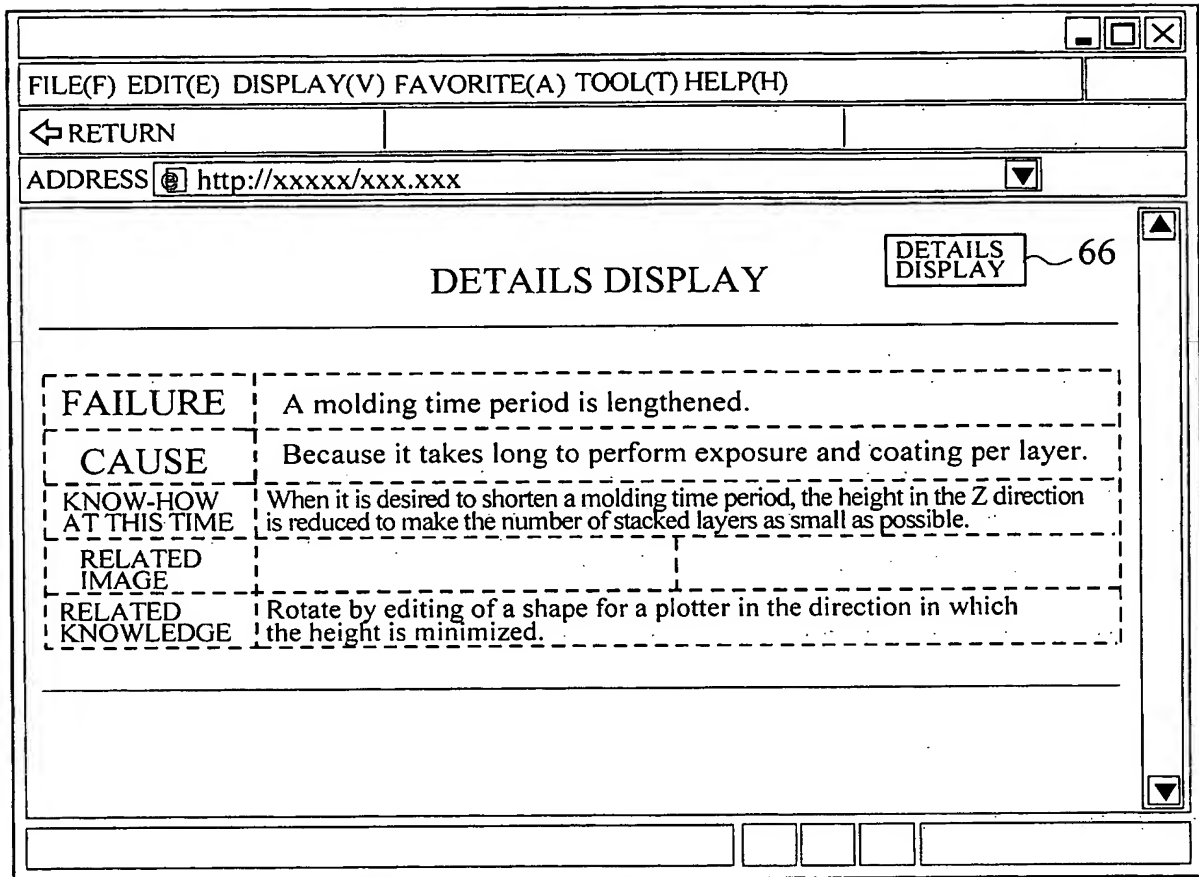


FIG.17

